

Date: Thursday, 3/16/2006 10:37:37 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SHUT-OFF VALVE SHAFT
Job Number	: 26267		
Estimate Number	: 12193		
P.O. Number	:	Part Number	: D3470041
This Issue	: 3/16/2006	S.O. No.	:
Prsht Rev.	: NC	Drawing Number	: D3470 REV.A
First Issue	: / /	Project Number	: N/A
Previous Run	:	Drawing Revision	: A
	Type : PURCHASED PARTS	Material	:
Written By	: <u> </u>	Due Date	: 3/31/2006
Checked & Approved By	: <u> </u>	Qty:	1
Comment	: est rev A 06.02.06 new issue EC	Um:	Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D34703	ARM
-----	--------	-----



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty	Part number	Description	batch
1	D3470-3	ARM	

2.0	D34701	SHAFT
-----	--------	-------



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty	Part number	Description	batch
1	D3470-1	Shaft	

3.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
-----	-------------	------------------------------



Comment: LARGE FABRICATION RESOURCE 1

Weld assembly as per dwg D3470

4.0	QC5/9	WELD INSPECTION
-----	-------	-----------------



Comment: WELD INSPECTION

5.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SHUT-OFF VALVE SHAFT

Job Number: 26267

Part Number: D3470041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL
Inspection Level 21

Job Completion



Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

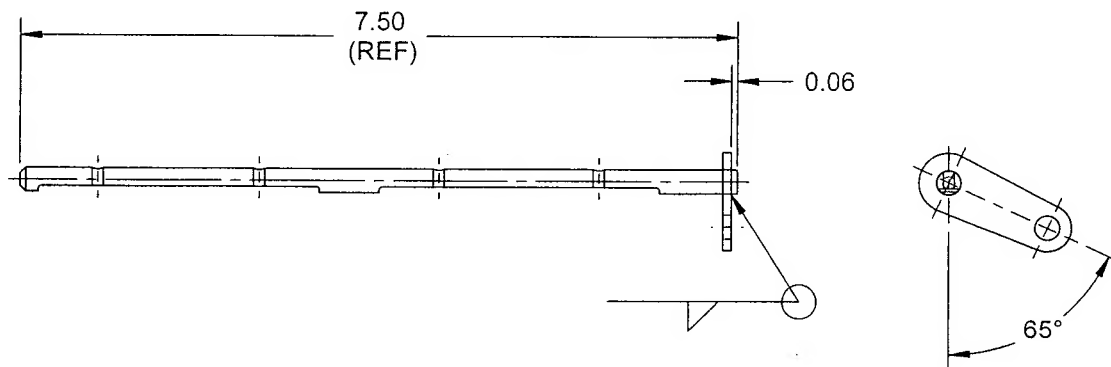
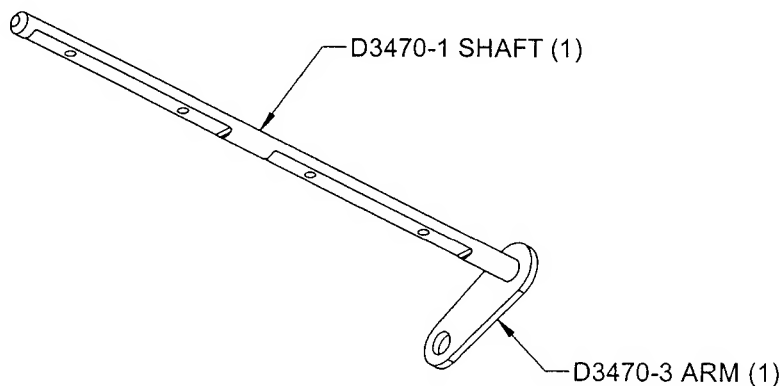
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

PRELIMINARY ISSUE

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3470	REV. A SHEET 1 OF 4
DATE 05.12.14		TITLE SHUT-OFF VALVE SHAFT	SCALE 1:2
A	05.12.14	NEW ISSUE	



D3470-041 SHUT-OFF VALVE SHAFT

NOTES:

- 1) WELD PER DART QSI 004
- 2) FINISH: ELECTRO-CHEMICALLY POLISH
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

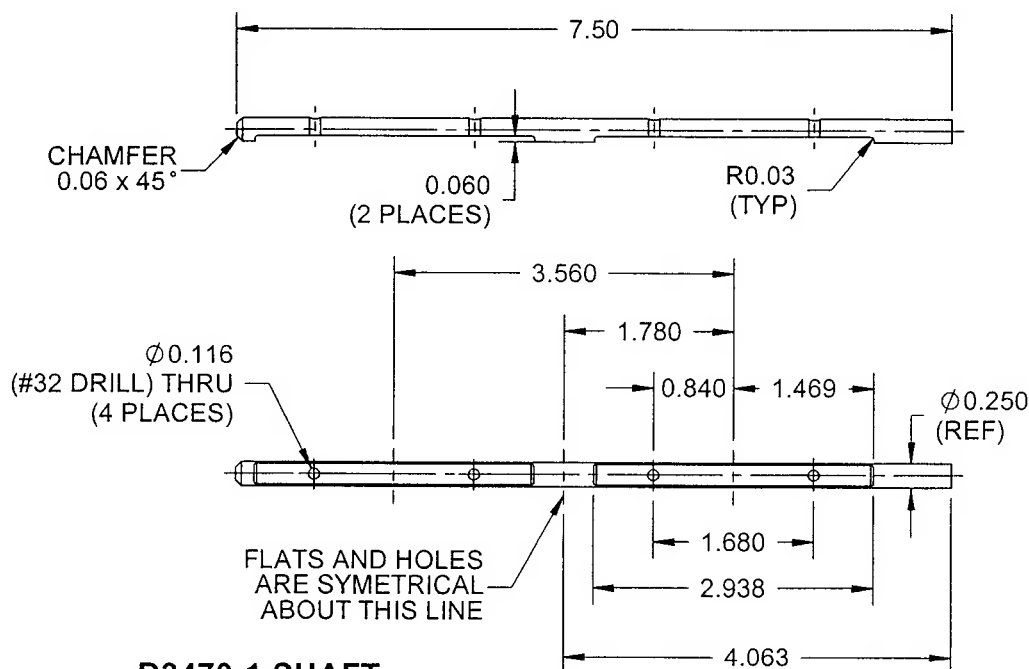
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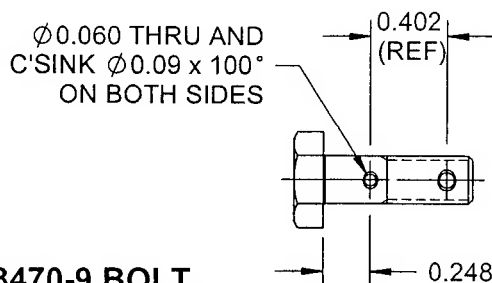
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CHECKED	APPROVED	DRAWING NO. D3470	REV. A SHEET 2 OF 4
DATE 05.12.14		TITLE SHUT-OFF VALVE SHAFT	SCALE 1:2



D3470-1 SHAFT

- 1) MATERIAL: AISI 303 STAINLESS STEEL 0.25 ROUND BAR
(REF. DART SPEC. M303R0.250)



D3470-9 BOLT

SCALE 1:1

- 1) MAKE FROM AN4-6 BOLT

NOTES:

- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
3) ALL DIMENSIONS ARE IN INCHES
4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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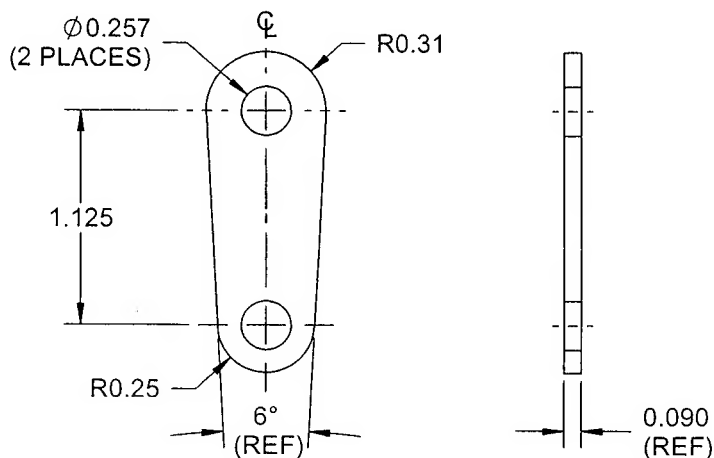
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DATE 05.12.14		TITLE SHUT-OFF VALVE SHAFT	SCALE 1:1

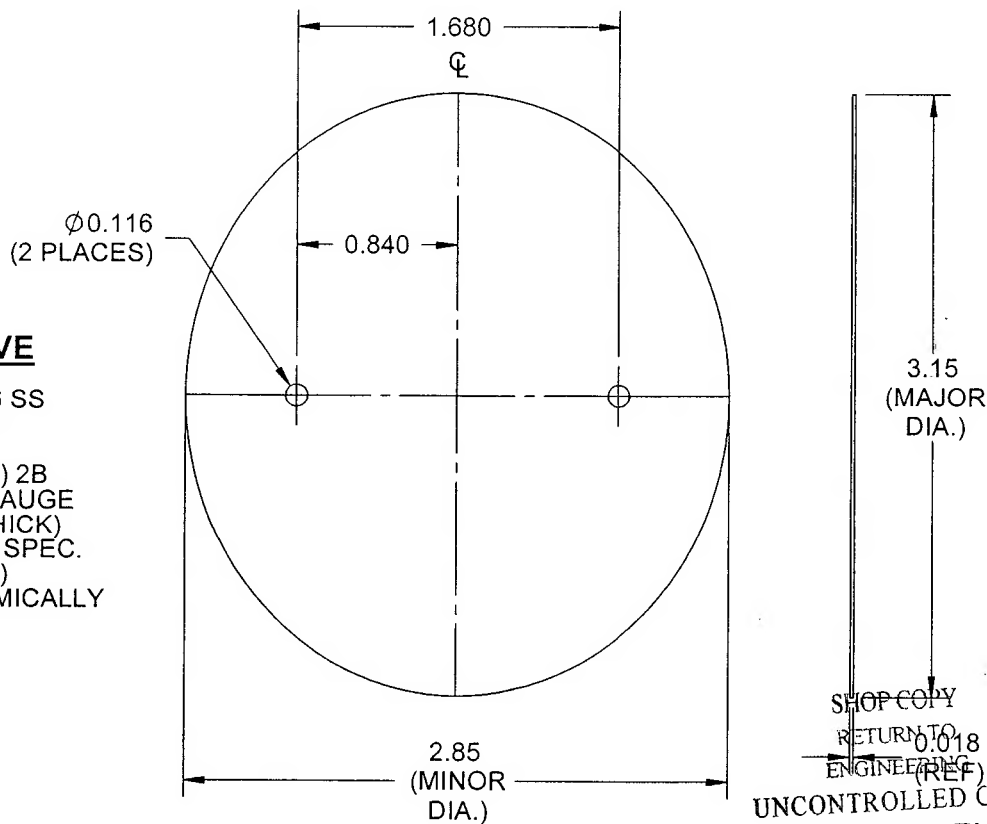
D3470-3 ARM

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH 13 GAUGE SS (0.090 THICK) (REF. DART SPEC. M304S26GA)
- 2) FINISH: NONE.



D3470-5 PLATE VALVE

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH 26 GAUGE SS (0.018 THICK) (REF. DART SPEC. M304S26GA)
- 2) FINISH: ELECTRO CHEMICALLY POLISH.



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NO. **26267**

NOTES:

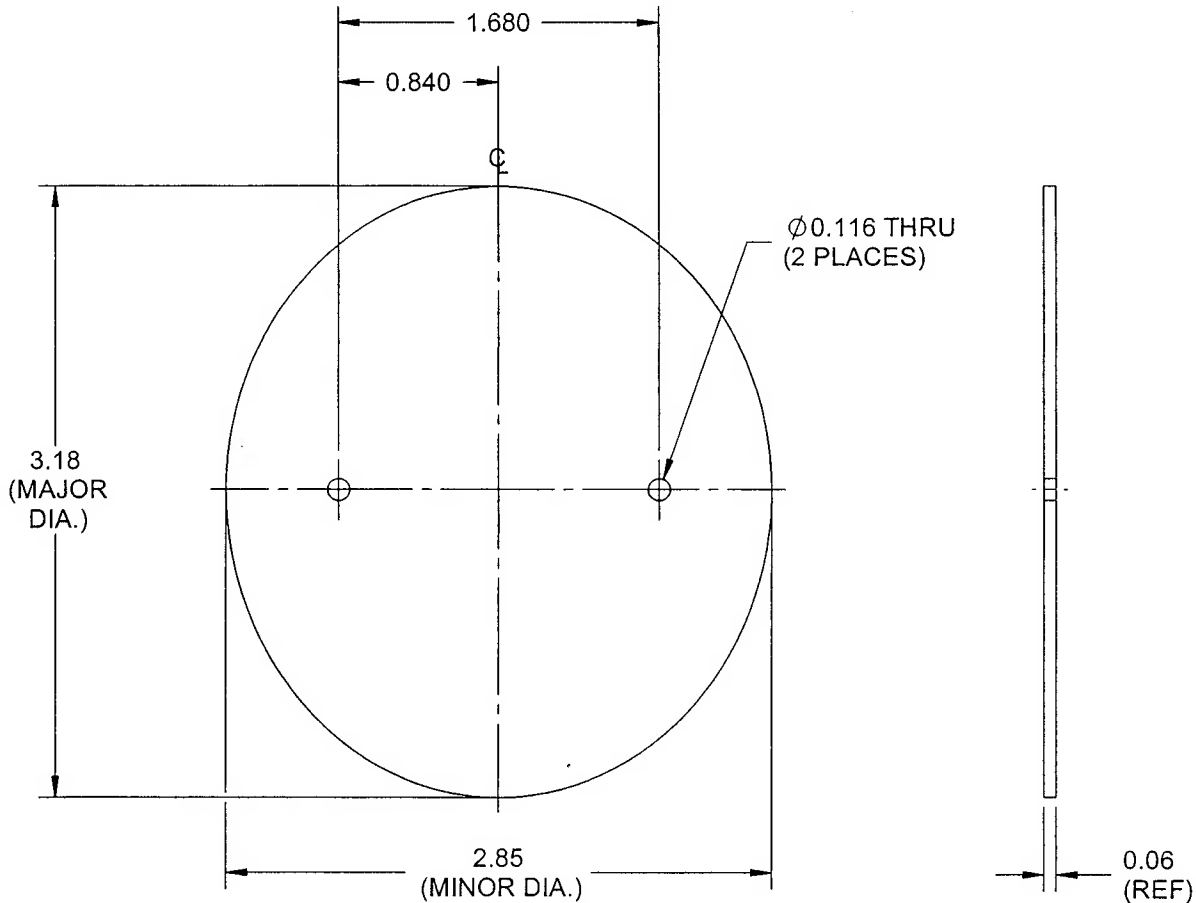
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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CHECKED	APPROVED	DRAWING NO. D3470	REV. A SHEET 4 OF 4
DATE 05.12.14		TITLE SHUT-OFF VALVE SHAFT	SCALE 1:1



D3470-7 VALVE SEAL

NOTES:

- 1) MATERIAL: RED (OR GRAY) 60 DUROMETER HI-TEMPERATURE SILICONE SHEET, 0.063 THICK (REF. DART SPEC. M-SIL60-S.063)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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